

Work Order ID 53134

October 23, 2009 8:07:18 AM



Page 1

Item ID: D3838-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 23/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PC*

Date: *09/10/23*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-1 and D3838-3 rib as per dwg D3838
2- remove identification markings
3- deburr

09.10.24 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 809/10/26

-041

(12)

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Page 2

Item ID: D3838-041
 Revision ID: A
 Item Name: Rib Assembly (Basket Lid, LH)
 Start Date: 23/10/2009 Start Qty: 2.00
 Required Date: 30/10/2009 Req'd Qty: 2.00
 Reference:

Accept



Setup Start



Stop



Cost Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838 A/R ER316 S.S. Rod Batch: <u>M109213</u> 2- c/sink hole as per dwg 3- grind weld flush where indicated on dwg D3838 4- weld D3759-1 bushing as per dwg D3838 5- grind bushing weld flush as per dwg dwg D3838 6- deburr hole if necessary								
130 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

Pl 09 10 27

PD 09.10.27

Work Order ID 53134

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Page 3

Item ID:	D3838-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	23/10/2009	Start Qty:	2.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	→ 809/10/28			241 ②	7		
150 Packaging Packaging	Identify as per dwg & Stock Location <u>Basket</u> Memo	0.00 0.00				D 09.11.02			
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/11/03 MF 09-11-02			

Picklist Print

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Page 1

Work Order ID: 53134



Parent Item: D3838-041RevA



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 23/10/2009

Required Date: 30/10/2009

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	468.3119	2.1720			

304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

468.3118947

112398

468.311895

120

Each

60.0000

2.0000

PD 09.10.24

D3759-1RevA

Manufactured

No



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

60

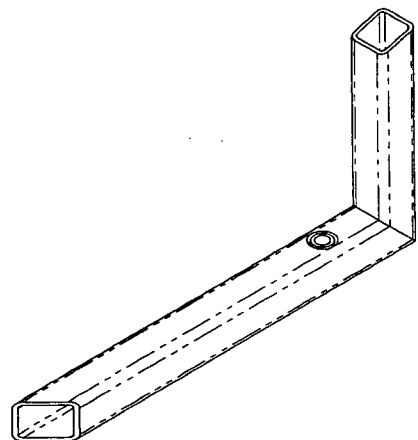
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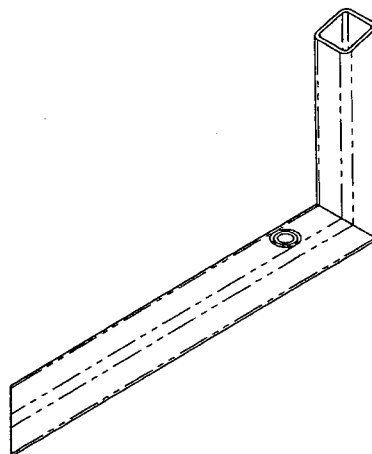
51473

36

② 09.10.27 ✓



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

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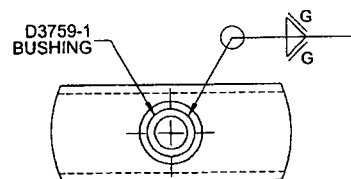
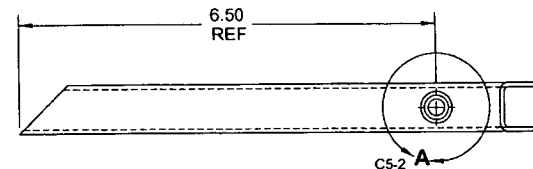
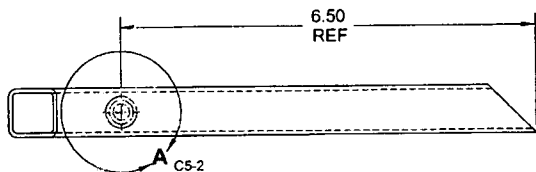
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

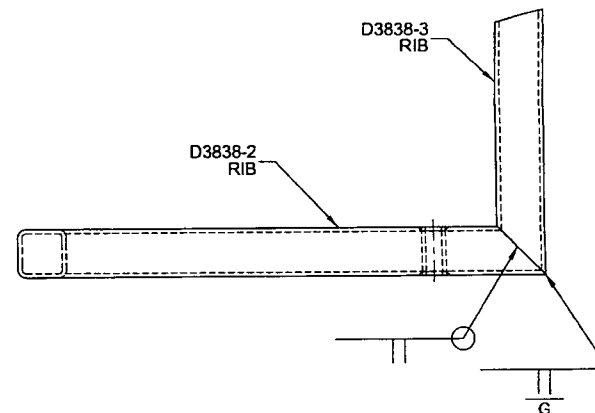
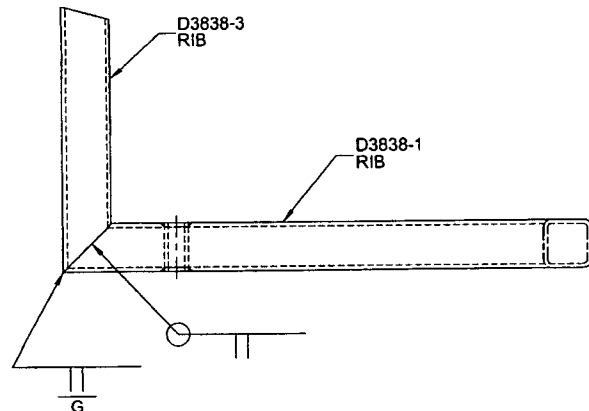
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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DETAIL A
D2-2 SCALE 2X
D7-2



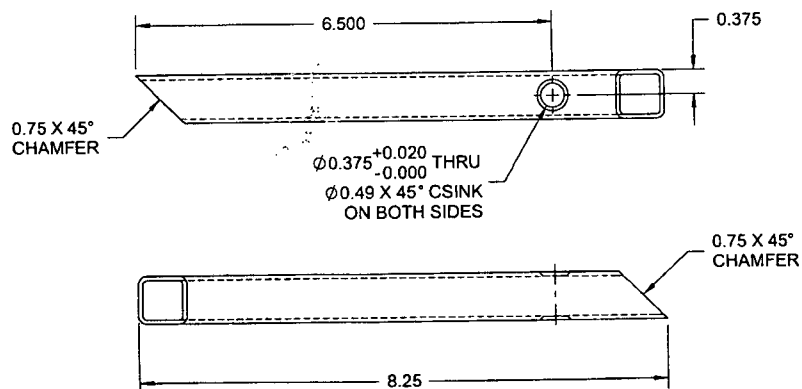
D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, LH)

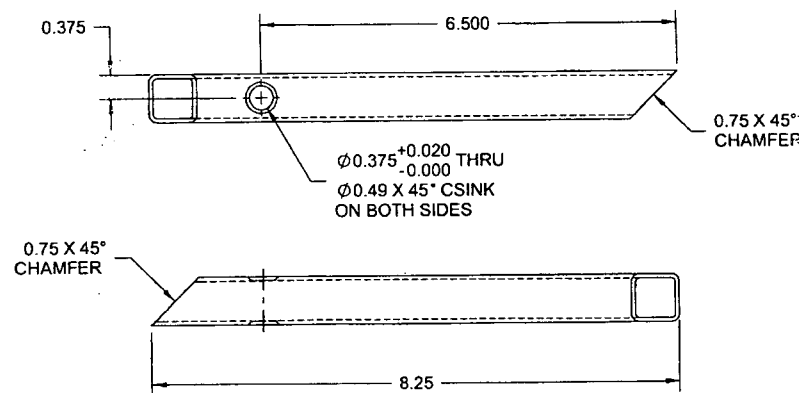
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08/10/08

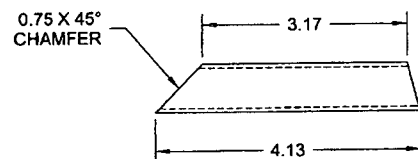
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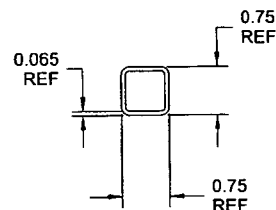
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

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26/11/18

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3838-1/2 = 0.35 lbs EACH; D3838-3 = 0.19 lbs

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
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